

Date: Monday, 12/01/2009 2:29:55 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services			<b>Drawing Name</b>	: BRACKET ASSEMBLY		
<b>Job Number</b>	: 44551			<b>Part Number</b>	: D2804042		
<b>Estimate Number</b>	: 10334			<b>Drawing Number</b>	: D2804 REV C		
<b>P.O. Number</b>	:			<b>Project Number</b>	: N/A		
<b>This Issue</b>	: 12/01/2009 <b>S.O. No.</b> :			<b>Drawing Revision</b>	: C		
<b>Prsht Rev.</b>	: NC			<b>Material</b>	:		
<b>First Issue</b>	: / / <b>Type</b> : SMALL /MED FAB			<b>Due Date</b>	: 30/01/2009 <b>Qty:</b> 4 <b>Um:</b> Each		
<b>Previous Run</b>	: 44492						
<b>Written By</b>	:						
<b>Checked &amp; Approved By</b>	: <u>JUL 09.01.12</u>						
<b>Comment</b>	: Est F 05.03.30 MS21043-3 was MS21042L3 Est Rev:G As per Rev C 06-11-08 JLM			KJ/JLM			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D28042	Bracket	
		<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) STA 155 Bracket Pick: Qty Part Number Description Batch	
	1 D2804-2	Bracket	<u>B44476</u>
2.0	D28052	Stop	
		<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Stop Pick: Qty Part Number Description Batch	
	1 D2805-2	Stop	<u>41707</u>
3.0	D2809	Bushing	
		<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Bushing Pick: Qty Part Number Description Batch	
	1 D2809	Bushing	<u>38917 40929</u>
4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE	
		<b>Comment:</b> SMALL & MEDIUM FAB RESOURCE 1 Press D2805-2 into arm as per Dwg D2804	<u>EP09/01/23 (2)</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/01/2009 2:29:55 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 44551

Part Number: D2804042

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC5

INSPECT WORK TO CURRENT STEP



10501-23(4)

Comment: INSPECT WORK TO CURRENT STEP

6.0 POWDER COATING

POWDER COATING



m109996



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 8:30

OVEN TEMPERATURE: 320°

FINISH TIME: 9:30

(4)

Fd 09/01/26

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press Fit D2809 as per Dwg D2804

S 09/01/27(4)

Am 09/01/26(8)

9.0 AN3C16A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
2	AN3C16A	Bolt	107734 M109147

10.0 MS210433

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
2	MS21043-3	Nut	M110023

8 09/01/27(4)

8 09/01/27(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/01/2009 2:29:55 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 44551

Part Number: D2804042

Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 NAS151H3

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Washer

Pick:

Qty Part Number Description

Batch

4 NAS151H3

Washer

M 109268

A/R

LPS-3

Corrosion Spray

SS 09/01/27 X4

12.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804

2-Assemble as per Dwg D2804.

BB 09/01/27 X4

13.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/01/27 X4

14.0 PACKAGING 1

PACKAGING RESOURCE #1



X4

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 159

all 27

50

15.0 QC21

FINAL INSPECTION/W/O RELEASE



09/01/28 X4

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 09/01/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

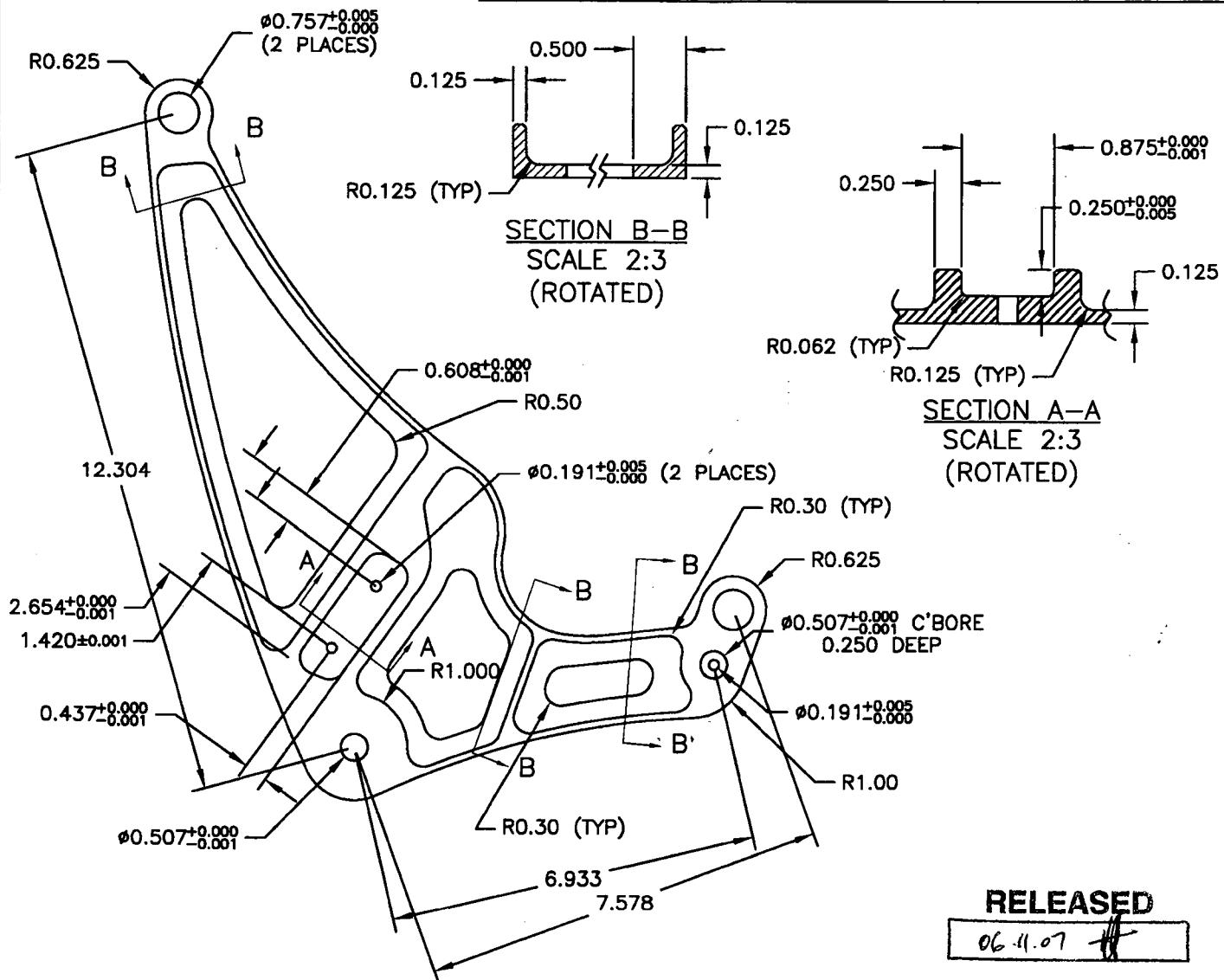
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <del>✓</del>	APPROVED <del>✓</del>	DRAWING NO. D2804	REV. C SHEET 1 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	
C	06.10.16	CHANGE GEOM. TO ADD CLEARANCE	



RELEASED

06.11.07 ~~+~~

D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
  - 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500
  - 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
  - 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**SHOP COPY**

RETURN TO

## ENGINEERING

UNCONTROLLED COPY

~~SUBJECT TO AMEND~~

WITHOUT NOTICE

WORK ORDER

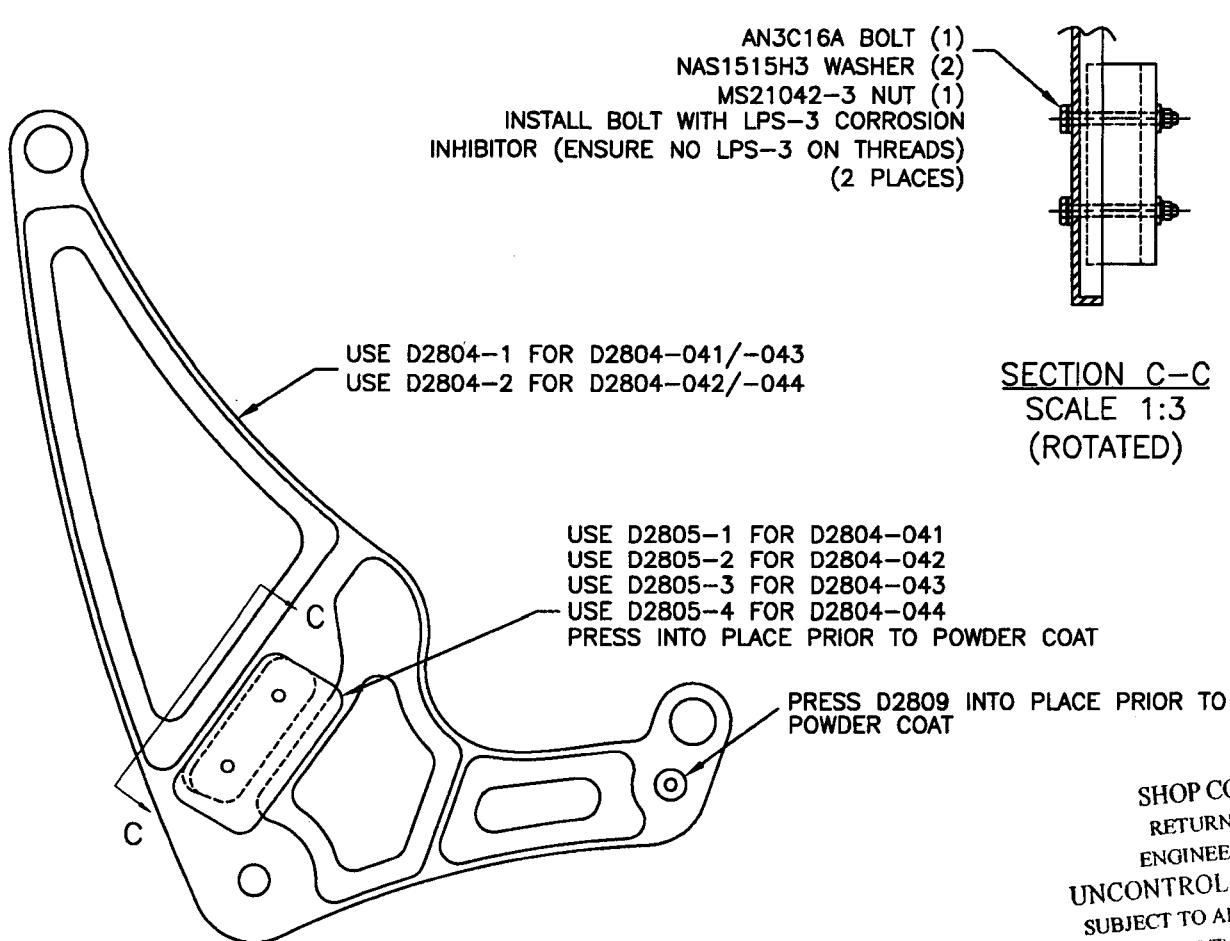
## NOTES

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**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3



**D2804-041/-043 BRACKET ASS'Y (SHOWN).**  
**D2804-042/-044 BRACKET ASS'Y (OPPOSITE)**

- 6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANTEX (4.3.5.6) OR BLACK SANTEX (4.3.5.7) OR GREEN SANTEX (4.3.5.8) PER DART QSI 005 4.3